

IN THE SPECIFICATION

Please amend paragraph [0015] as follows:

[0015] Preferably, the metallic material for the cap includes, for example, tin-free steel, electrolytic-tin plate, and aluminum; although the manufacturing process is different for aluminum caps. Before punching the metallic element 11 in the shape of a crown cap, one or several layers of printing ink (not shown) are deposited on the upper surface 12 in order to differentiate one crown design from another mainly with the logo of the beverage producer, the logo of the beverage brand, or promotional messages. In order to increase production, it is normal to start the manufacturing process with a metal sheet from which a large amount of caps is made. The application of the ink layers is typically made through one or several lithographic processes such as offset, etc. Once applied, the ink imprints are cured in a continuous oven, or furnace, at temperatures ranging from about 150 to about 180 °C, and more preferably between about 160 and about 165 °C. The residence time of the metallic sheets in the curing oven is varied between about 7 and about 15 minutes, and more preferably between about 8 and about 9 minutes. It is also possible to imprint these labels and logos, or any other promotional messages, on the under portion 14 of the linerless crown cap [[30]]10.